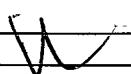
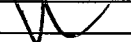


Date: Tuesday, 23/12/2008 1:22:28 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STEP SPACER
Job Number :	44293B		
Estimate Number :	10354		
P.O. Number :		Part Number :	D2322
This Issue :	23/12/2008	Drawing Number :	D2322 REV C
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	C
Previous Run :	40087B	Material :	
Written By :		Due Date :	05/01/2009
Checked & Approved By :		Qty:	16
Comment :	Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now on Waterjet 06-07-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M2024T3S040	2024-T3 .040 sheet
-----	-------------	--------------------



Comment: Qty.: 0.2132 sf(s)/Unit Total : 3.4104 sf(s)
 Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick
 (M2024T3S.040)
 Identify as D2322
 Batch: 107572 RB 8-12-30

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D2322
 Dwg Rev: C
 Prog Rev: C

RB 8-12-30

(20)

2-Deburr if necessary RB 8-12-30

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RB 8-12-30

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

08-12-30

(20)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
 Form as per Dwg D2322

SB 09/01/20

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/12/2008 1:22:28 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 44293B

Part Number: D2322

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

S 02/01/20 (X20)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(20X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L 02/01/23

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

05-01-23

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Sylone

SS 09/01/23 (20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/26 (X)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 07-01-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries


DART AEROSPACE LTD	Work Order: 442938
Description: STEP SPACER	Part Number: D2322
Inspection Dwg: D2322, Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X

[illegible]

Measured by:	IB
Date:	8-12-36

Audited by:	
Date:	08.12.30

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



DESIGN BW	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2322	REV. C SHEET 1 OF 1
DATE 98.09.29		TITLE STEP SPACER	SCALE 1:2
A	94.10.14	NEW ISSUE	
C	98.09.29	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER NCR 001	

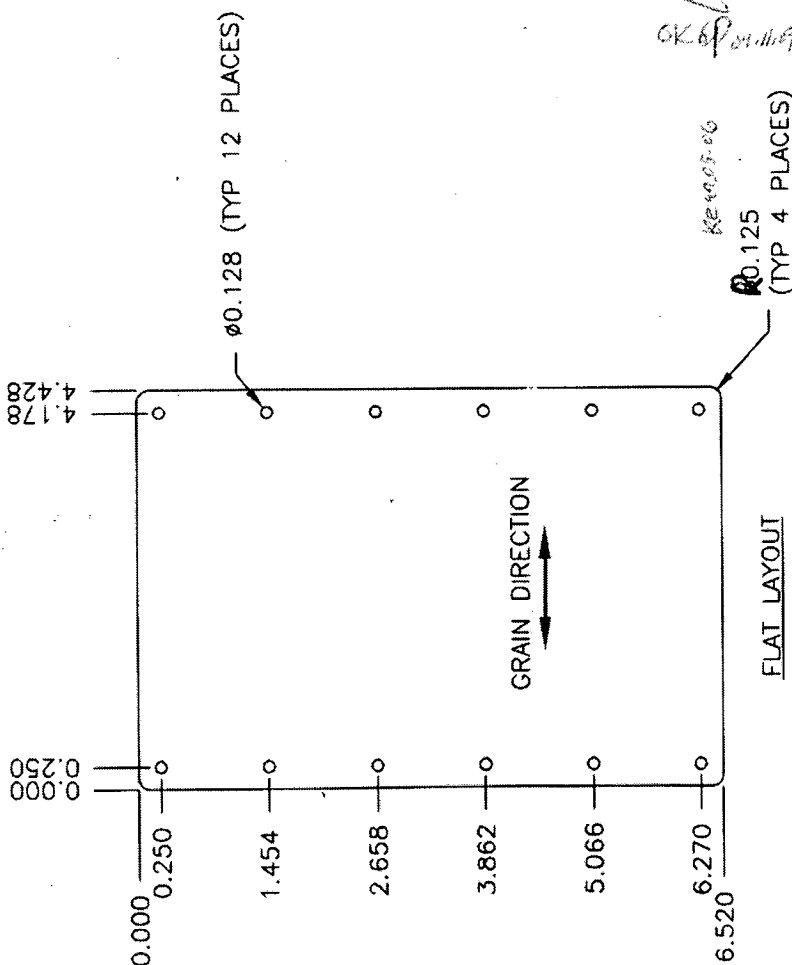
RELEASED
98.10.08 DS

UNDER REVIEW

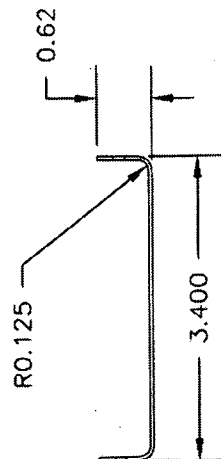
01.03.15 CP

DESIGN OK, BUT CHECK WITH
JIS BEFORE MANUFACTURE

OK CP 01.03.15



w/o
44283B



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries